

Date: Friday, 06/06/2008 11:01:44 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-TUBE MATERIAL
Job Number	: 39734		
Estimate Number	: 12127		
P.O. Number	:	Part Number	: D6005180
This Issue	: 06/06/2008 S.O. No. :	Drawing Number	: D6005 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 38345	Material	:
Written By	:	Due Date	: 13/09/2008 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:C 04.06.15 Added tolerance to Step 2 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6521

C 208/06/06 (20)

- a) Extrude as per Dwg D6005 length = 180" (Ref. D6005-180)
- b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11)) Seamless aluminum tube
- c) Minimum ultimate tensile strength = 77ksi
- d) Minimum tensile yield strength = 66ksi
- e) Material certification required

2.0	D6005180P	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Crosstube extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

AS 08/09/16 (FC)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6005

508/06/07 (x13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/06/2008 11:01:44 AM
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Drawing Name: X-TUBE MATERIAL

Job Number: 39734

Part Number: D6005180

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Back hall

25 08-09-12

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



MF 08-09-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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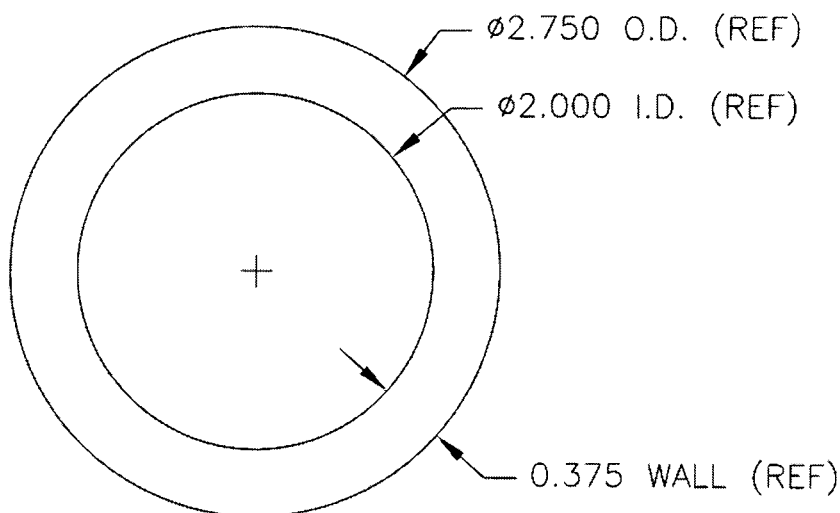
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D6005	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 *A*



NOTES

- 1) D6005-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 128" LONG TUBE: D6005-128

u39734

- 2) MATERIAL: 2.750 OD x 0.375 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY)
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Packinglist ALUnna AG

Customer PO	PO. 00006521
ALUnna ref. no.	29893/1
Date:	08.21.08

Boxmarking:

Dart Aerospace PO. 00006521
Made in Germany
Dest.: Hawkesbury Ont. Canada

We hereby declare that the wooden packing material are totally free from bark and apparently

free from live plant pests

[illegible]

8/10

Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

Kunde: Dart Aerospace Ltd.
Client: 1270 Aberdeen Street
K6A1K7 Hawkesbury, ON Canada

Zeugnisnummer: 1283/08
Cert No. / No. du certificat:
Bestellnummer: PO 00006521
Order No. / No. de commande
Auftrag: 29893/1
Our Reference/Notre Reference:

Produkt: Rohre nahtlos gepresst
Product / Produit: Tubes seamless extruded
Spezifikation: -; AMS - QQ - A - 200/11E; -; -; Spezifikation Dart Aerospace D 6005
Specification:

Werkstoff: 7075
Alloy/Alliage: **Zustand:** T 6511
Temper/État

Abmessung 2,750 INCH x 2,000 INCH x 0,375 INCH x 180,000 INCH
Size / Dimension D6005-180 2.750 x 0.375 x 180

Kennzeichnung ALUnna - Cert No. 1283/08 - 7075 - T6511 - Cast No. 81742 - AMS - QQ - A - 200/11 - 2.750" OD X 0.375" Wall -
Marking/Marquage: Heat Lot No. 1837 - ALUnna Order Conf. 29893/1-1 - P.O.00006521

Lieferung Stück kg
Delivered Material / Matériel délivré: 13 301,00

1. Chemische Analyse Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
81742	0,07	0,13	1,38	0,04	2,45	0,19	5,73	0,04	0,01	0,03	0,01	0,01	0,01

2. Mechanische Eigenschaften Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
min.	77,0	66,0				
max.						
1	85,695	78,590	10,0		162	1837 - 13 pcs.

Ergebnis der Prüfungen: Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results: We confirm that the delivery has been tested and applies to the agreements made on receipt of the order
Resultats: Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

22.08.2008 / Duda



Certified acc. DIN EN ISO 9001:2000 and DIN EN 9100:2003
valid until 2010-11-11
Cert. - Reg. No.: 001959 QM; 001959 ASH



ALUnna

Abnahmebeauftragter

Aluminiumwerk Unna AG, Uelzener Weg 36, 59425 Unna, Germany



Une société de Transforce

Téléphone : 450 641-9051 fax : 641-9247

4, Chemin du Tremblay, Boucherville (Québec) J4B 6Z5

www.transpel.ca

D - 17803

Date: 09/15/2008 Facturé A / Billed to : MSC S/S Stemship co LTD

Tracteur Tractor	Chassis Remorque / Trailer	Chauffeur Driver	Date de livraison date of delivery	Heure de livraison Time of delivery
24304	2017	ROBERT CHRISTIAN	09/16/2008	3:01

Full	X	Empty	F / B	Toile	Temp
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Expéditeur / Shipper	Disponible à / Available at	Date & heure de ramassage / Date & time pickup
MSC 360 St-Jacques suite 900 MONTREAL, PQ CA H2Y 3X1	TERMONT ^{TER} 001	09/15/2008
	Booking	Bateau & voy / Vessel & voy
	MSCUHB332602	MSC SERENA 56A

1er Consignataire / 1st Consignee	Conteneur / Container #	Taille / size
DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON	MSCU7564400	40 HC
	# de Sceau / Seal #	Poids / Weight
	219833	12409

2e Consignataire / 2nd Consignee	# Conteneur / Container #	Taille / Size
TRANSTERM 7600 NOTRE DAME OUEST MONTREAL, PQ H4C 3K4 514-368-1482		
	Port de / of destination	P/U Ville

Traverse douanière et courtier Border crossing and broker	Heure d'arrivée / Time of Arrival	Heure de départ / Time of departure
	2:30	

Remarque / Remarks
P/U# 43593723

Matières dangereuses / Hazardous materials				
UN #		PG #		CLASS

NOTE AU CLIENT / NOTE TO CUSTOMER

ASSUREZ-VOUS QUE LE SCEAU EST INTACT À LA LIVRAISON / ENSURE SEAL IS INTACT AT TIME OF DELIVERY
AUCUNE RÉCLAMATION NE SERA ACCEPTÉE SANS AVIS AU MOMENT DE LA LIVRAISON
NO CLAIM WILL BE ACCEPTED UNLESS REPORTED AT TIME OF DELIVERY

Exceptions :

Imprimez client / print customer	Signature
Imprimez chauffeur / print driver	Signature
CHRISTIAN ROBERT	Robert Christian

TOUT TEMPS D'ATTENTE CHEZ CE CLIENT DEVRA ÊTRE SIGNÉ PAR LE CLIENT "TIME IN" ET "TIME OUT" OU VOUS NE SEREZ PAS PAYÉ. VOUS DEVEZ AUSSI EN TOUT TEMPS, RAPPORTER LA FORMULE DU CLIENT (FEUILLE DE DÉTAILS DU VOYAGE 8,5 X 11) PRELVE DE RÉCEPTION (SIGNATURE OU ESTAMPE)

COPIE DU CHAUFFEUR / DRIVER'S COPY

**MEDITERRANEAN SHIPPING COMPANY (CANADA) Inc**

360, St. Jacques Street, Suite 900, Montreal
Phone: +1 514 844 3711 Fax: +1 514 844 4272

Date: 5.15.2004
Time: 9.12 AM

Delivery Order

TO THE ATTENTION OF

TRANSPHEL

205 CHEMIN DU TREMBLAY

Deliver Container To: DART AEROSPACE
1270 ABERDEEN ST.
Hawkesbury, ON K6A 1K7

Contact: LINDA LACELLE
Telephone: 613-632-9577

Fax:

Consignee: TRANSWORLD SHIPPING USA INC

Drop Off EMPTY At:

Scheduled Appointment:

TOFC / COFC: COFC

Live Unload: Yes

Comments:

Pick Up At: Montreal, QC - (.) - TERMONT

PLEASE CALL BEFORE DELIVERY

Vessel / Voyage: MSC SERENA / 56A

Port Of Load: Bremerhaven, HB, Germany

Port Of Discharge: Montreal, QC

Please pickup the following container(s):

CONTAINER TYPE	CONTAINER NUMBER SEAL NUMBER LAST FREE DATE	B/L NUMBER SHIPPER REFERENCE PICK UP NUMBER	WEIGHT	NUMBER of PACKAGES COMMODITY HAZARDOUS INFORMATION	PACKAGE TYPE
40' High Cube	MSCU7564400 W219833	MSCUHB332602 43593723	5,629 kgs.	9 BOXES ALU TUBES HS CODE: 7608208 FREIGHT + ONCARRIAGE PREPAID WAYBILL STRAIGHT CONSIGNMENT AUTOMATIC CARGORELEASE ACI INFORMATION: ACI SUB-MITTED AND PROCESSED BY TRANSWORLD SHIPPING UNDER CBSA CODE 8U22106080573500 Non-Hazardous	Box(es)

Total Weight: 5,629 kgs.

If you have any questions, please call Brahim Bakri at +1 514 844 3711